

Date: Monday, 6/5/2006 11:01:41 AM
 User: Kim Johnston

Process-Sheet

| | | | | | | |
|-----------------------|---|----------------|------------------|---------------|-----|------|
| Customer | : CU-DAR001 Dart Helicopters Services | | Drawing Name | : LUG | | |
| Job Number | : 27417 | | Part Number | : D2561 | | |
| Estimate Number | : 10271 | | Drawing Number | : D2561 REV B | | |
| P.O. Number | : N/A | | Project Number | : N/A | | |
| This Issue | 6/5/2006 | S.O. No. : N/A | Drawing Revision | : B | | |
| Prsht Rev. | : NC | | Material | : N/A | | |
| First Issue | : N/A | | Due Date | : 6/26/2006 | | |
| Previous Run | : 25968 | | Qty: | 30 | Um: | Each |
| Written By | : <i>See J. Comment below</i> | | | | | |
| Checked & Approved By | : <i>John 06-06-05</i> | | | | | |
| Comment | : Est C 00.05.19 Added inspect level 8 EC | | | | | |

Additional Product

Job Number:



| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|
|---------|-----------------------|---------------|

| | | |
|-----|--------------------|-------------------------|
| 1.0 | M6061T6B0250X06000 | 6061-T6 Bar .25" x 6.0" |
|-----|--------------------|-------------------------|



Comment: Qty.: 0.3850 f(s)/Unit Total : 11.5511 f(s)

Material: 6061-T6, or 5052-H34 6.00" x 0.25" Thick

Batch: *1100782* *m17869*
12 ft *2 ft*

06 06 07

| | | |
|-----|----------|----------|
| 2.0 | BAND SAW | BAND SAW |
|-----|----------|----------|



Comment: BAND SAW

1-Cut blanks: 8.70"

Note: 1 blank makes 2 parts

| | | | |
|-----|-------|-----------|--------------------------------|
| 3.0 | HAAS1 | Water jet | HAAS CNC VERTICAL MACHINING #1 |
|-----|-------|-----------|--------------------------------|



Prog. Rev. *B*
 Dwg Rev. *B*

11/06/07 30

Comment: HAAS CNC VERTICAL MACHINING #1

1-Machine as per folio D2561

2-Deburr, no sharp edges

| | | |
|-----|-----|--|
| 4.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE |
|-----|-----|--|



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

11/06/07 30

| W/O: | | WORK ORDER CHANGES | | | | | | | |
|------|------|--------------------|--|--|----|------|-----|---------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | | | By | Date | Qty | Approval Mfg / Design Mgr | Approval QC Inspector |
| | | | | | | | | | |
| | | | | | | | | | |

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | | | |
|------|------|----------------------------------|-----------------------------|----------------------------------|----------------|---------------------------|------------------------|--------------------------|--|--|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Design Mgr | Approval QC Inspector | | |
| | | | Initial Design Mgr | Action Description Design Mgr | Sign & Date | | | | | |
| | | | | | | | | | | |
| | | | | | | | | | | |
| | | | | | | | | | | |

Part No: _____

PAR #: _____

Fault Category: _____

NCR: Yes

 NoDQA: Date: 06/06/15

NOTE: Date & initial all entries

QA: N/C Closed: _____

Date: _____

Date: Monday, 6/5/2006 11:01:41 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LUG

Job Number: 27417

Part Number: D2561

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 QC8 SECOND CHECK



30

Comment: SECOND CHECK

6.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



30

Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr, no sharp edges

540 06/06/11

7.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 5049

6/6/12 30

8.0 DC DOCUMENT CONTROL



30

Comment: DOCUMENT CONTROL

Inspection Level 21

10 06/06/13

Job Completion



U 06/06/13

Please
drill .257
holes. before
deburring



| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|---------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Mfg / Design Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|----------------------------------|----------------|---------------------------|------------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Design Mgr | Approval QC Inspector |
| | | | Initial Design Mgr | Action Description Design Mgr | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries QA: N/C Closed: _____ Date: _____

| | | |
|--|---------------------|--------------------|
| DART AEROSPACE LTD | Work Order: | <u>27417</u> |
| Description: Lug Plate | Part Number: | <u>D2561</u> |
| Inspection Dwg: D2561 Rev: B | | Page 1 of 1 |

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

| | |
|--------------|-----------|
| Measured by: | <u>MM</u> |
| Date: | 06.06.07 |

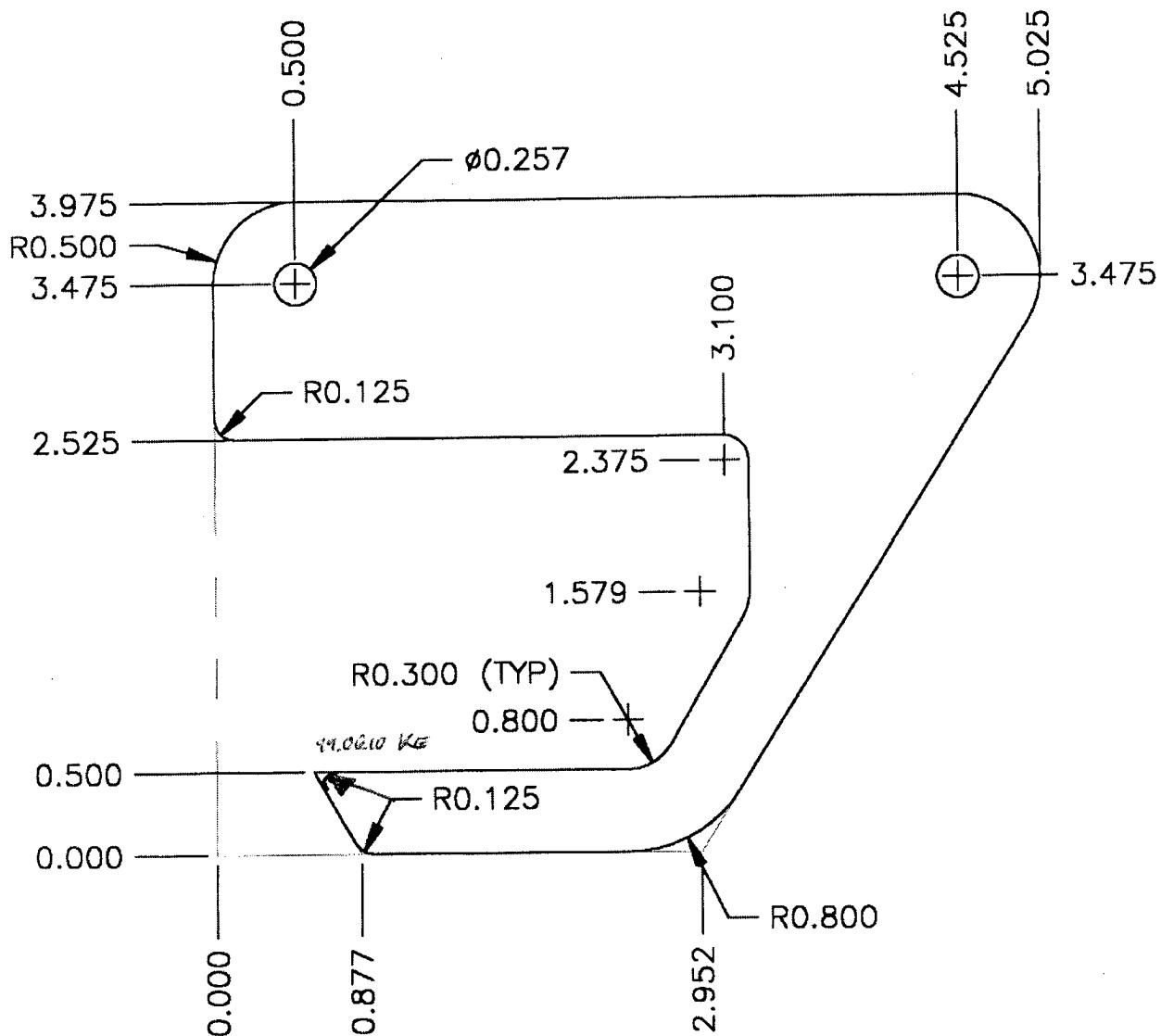
| | |
|-------------|---|
| Audited by: |  |
| Date: | 06-06 |

| | |
|---------------------|-----|
| Prototype Approval: | N/A |
| Date: | N/A |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|-----------|------------|----------|
| A | 04.01.21 | New Issue | KJ/RF | FF |

DART

| | | | |
|-----------------------|-------------------------|--|------------------------|
| DESIGN B. WILLIAMS | DRAWN BY B. WILLIAMS | DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA | |
| CHECKED <i>BW</i> | APPROVED <i>BW</i> | DRAWING NO. D2561 | REV. B SHEET 1 OF 1 |
| DATE 96.04.26 | | TITLE LUG PLATE | SCALE 1:1 |

RELEASED
96.05.06

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 27417